

Work Order ID 64032

November 23, 2010 10:08:03 AM



Page 1

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 11/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: C2 Date: 10/11/23 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4055	A

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

6061.063

Cut as per dwg D4055

Prog rev: A

Dwg rev: A

1810-12-9

(3)

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

1810-12-9

120 0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

10 12 09 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64032

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Item ID:	D4055-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tank Fwd End					
Start Date:	11/23/10	Start Qty: 3.00		Cust Item ID:		
Required Date:	11/30/10	Req'd Qty: 3.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00		SP 10/12/16		(3)			PTO next page
140 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		10.12.21		(X3)			
145 Hand finish 150 Packaging Packaging	Identify as per dwg & Stock Location: <u>ST</u> Memo	0.00 0.00		10.12.23 10.12.21		3			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	145	Chemical conversion coat	ll	10/12/21	X3		
	147	QC3	ll	10.12.23	3		
		Perm chg. →	BR	10-12-21	3.		
			CC	10.12.20			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 64032

November 23, 2010 10:08:03 AM



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Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 11/23/10 Start Qty: 3.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/03

U 11.01.03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.12.16	130	RELIEF ARE REQUIRED (SEE HAND CHG'S ON DWG). MAKE SURE THE RELIEF ARE ON FLAT PATTERN AND CUT AT SOME TIME ON WATERJET.				10.12.16 AS/042,		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

November 23, 2010 10:08:02 AM

Work Order ID: 64032



Parent Item: D4055-7



Parent Item Name: Tank Fwd End

Start Date: 11/23/10

Required Date: 11/30/10

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-7P 	<i>NA</i>	Purchased	No				Each	0.0000	1	3			<i>PTD</i>
Tank Fwd End													
M6061T6S.063 		Purchased	No			100	sf	41.2340	3.12	9.852632			<i>B 10-12-9</i>
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT21

41.234

113608

41.234

116308

116308

(3)

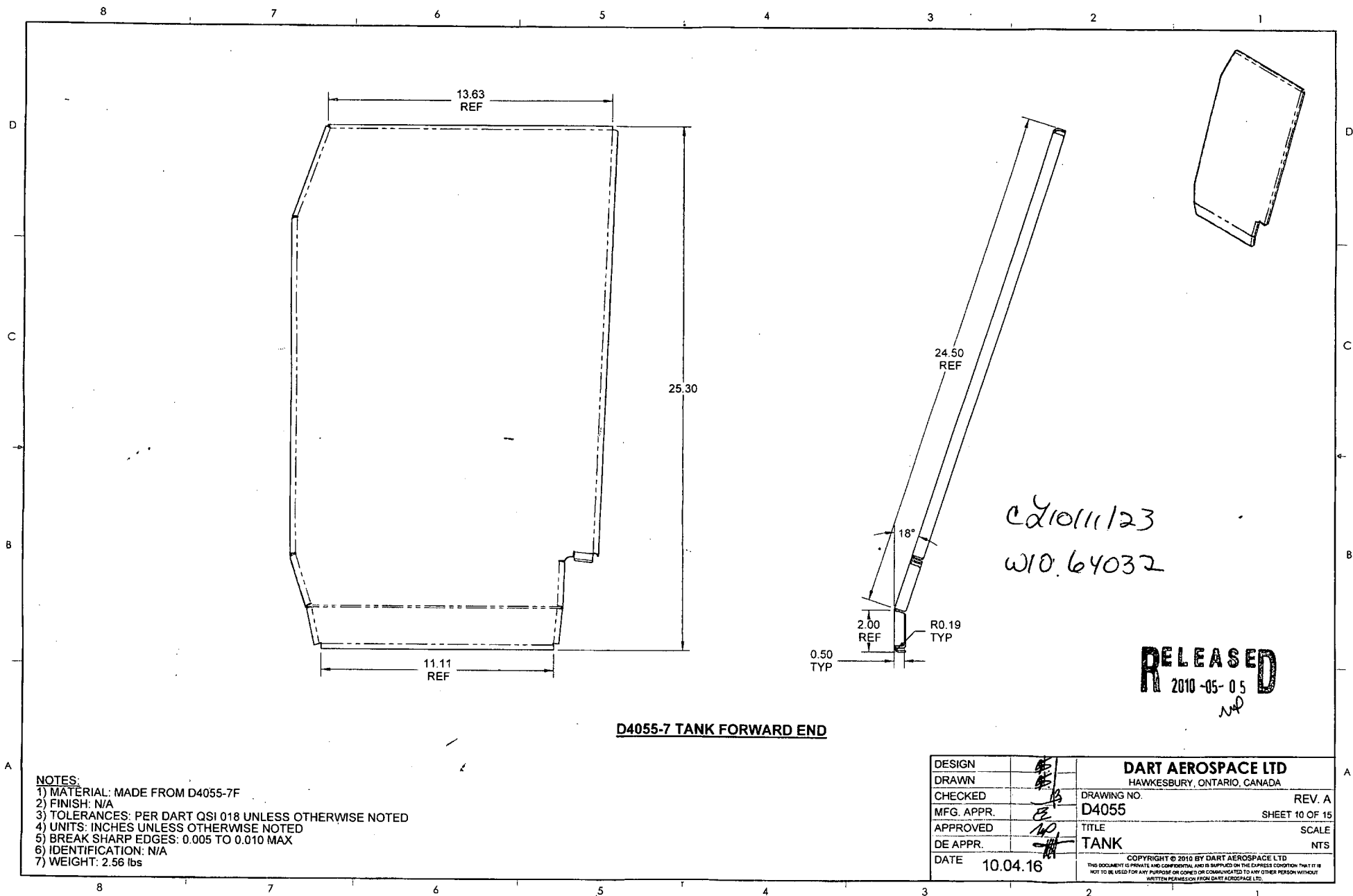
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-01-03		permanent change				<i>[Signature]</i> 10-01-03	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

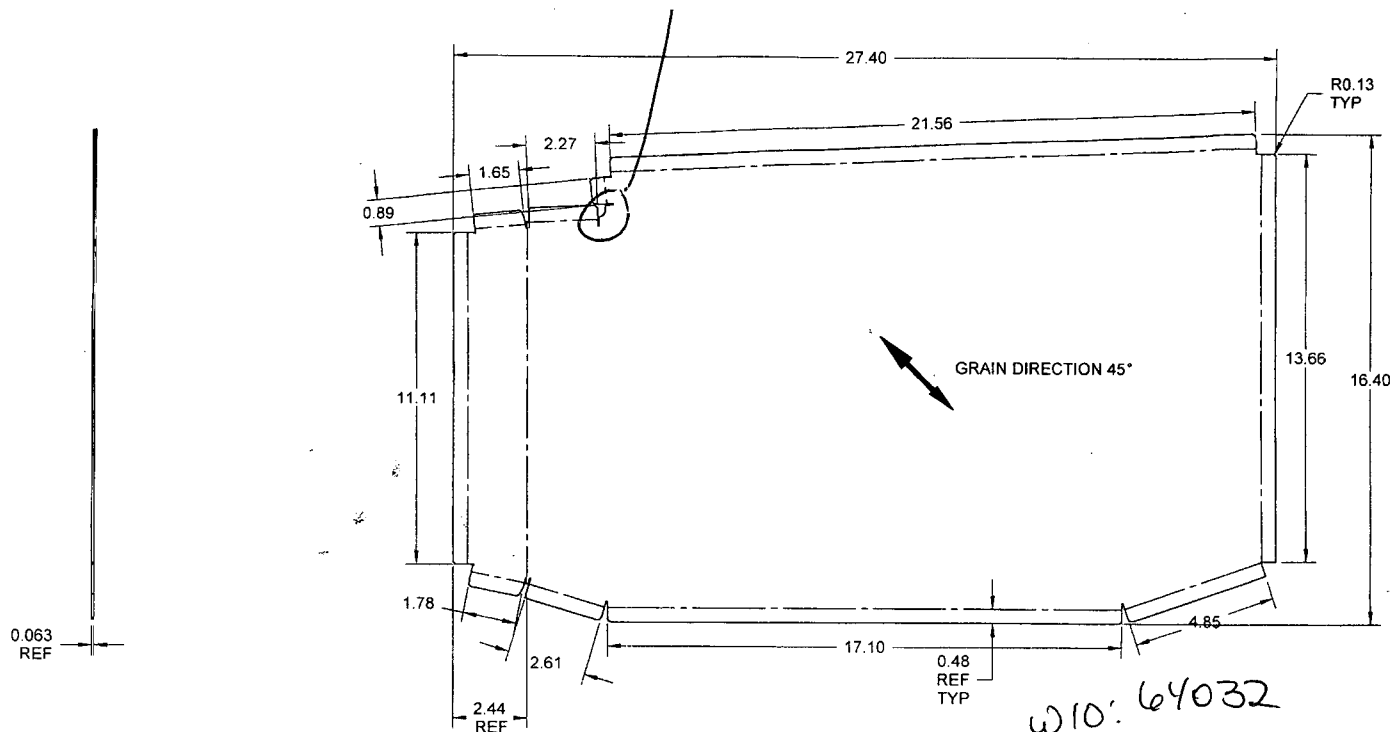
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NOTE: Date & initial all entries

MAKE ~~SEE~~ RELIEFS 0.250" LONG X THICKNESS OF
 610.1216 STEP #130 BLADE/TOOL.



W10: 64032

D4055-7F FLAT PATTERN

RELEASED
 2010-05-05
 MM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4055	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64032
Description: TANK FWD END	Part Number:	D4055-7
Inspection Dwg: D4055-7, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Prototype

[illegible]

Measured by:	IB
Date:	10-17-9

Audited by:	<i>M. M.</i>
Date:	10-12-09

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	